

SPLIT


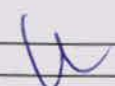


ASAP

Dart Aerospace Ltd.

Date: Monday, 15/12/2008 3:14:07 PM  
User: Linda Lacelle

Process Sheet

for Eagle

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING	
Job Number : 44096		
Estimate Number : 12418		
P.O. Number :	Part Number : D3484042	
This Issue : 15/12/2008 S.O. No. :	Drawing Number : D3484 REV E	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : E	
Previous Run : 43277	Material :	
Written By : 	Due Date : 22/12/2008 Qty:  Um: Each	
Checked & Approved By : 		
Comment : Est Rev:A New Issue 06-05-23 EC Est Rev:B 08-01-24 change rivet for CR1122-3-025 DD verified by:EC		

Additional Product

DID NOT SCANNED PARTS

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34842	Base, RH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 BASE, RH  
 Batch: 3344571

SP 08.12.18

2.0	D34844	Face, RH
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 FACE, RH  
 Batch: 343252

CP 08.12.22

3.0	D34846	Cone, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 CONE, RH  
 Batch: 336403

SP 08.12.18

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig  
 A/R AL ROD Batch: M 104855

CP 08.12.22

①

2-Buff & Smooth Welds to mating surfaces

SP 08.12.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 15/12/2008 3:14:07 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44096

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*08/12/23* ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08-12-23* ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FF 08/12/29* ①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L 08/12/29* ①

9.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch: *106878*

*FF 09-01-05* ①

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

ANCHOR NUT

Batch: *103693*

*FF 09-01-05* ①

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

*FF 09-01-05* ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*09-01-05* ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 15/12/2008 3:14:08 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44096

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



M109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:40

OVEN TEMPERATURE:

320°

FINISH TIME:

2:10

FL 09/01/05

(P)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



2H



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

(D)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP44094

AS 09/01/05 (X1)

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-142 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/05 (X1) RHC

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/06

MF 09-01-06

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

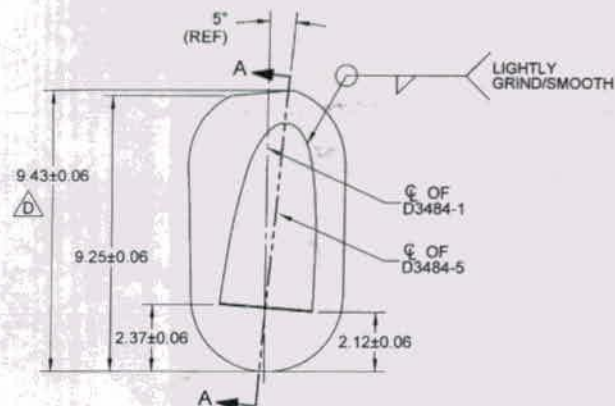
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

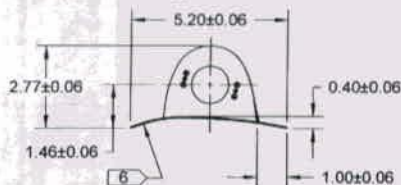
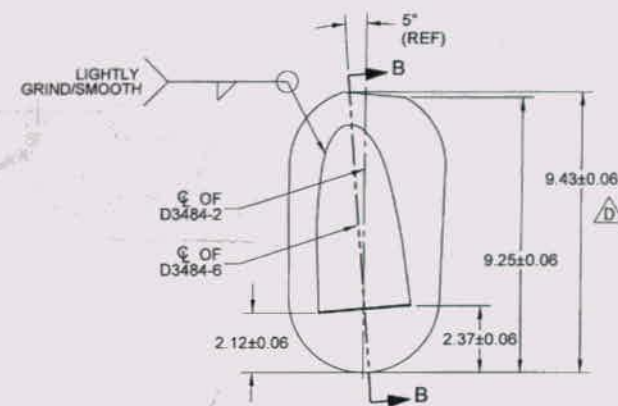
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
1		D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
1		D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
1		D3484-6	CONE (RH)
4		CR1122-3-02.5	RIVET
2		MS21069-04	ANCHOR NUT

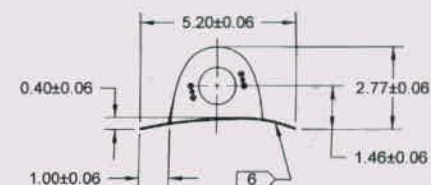


INSTALL MS21069-04  
ANCHOR NUT  
(2 PLACES)

**SECTION A-A**

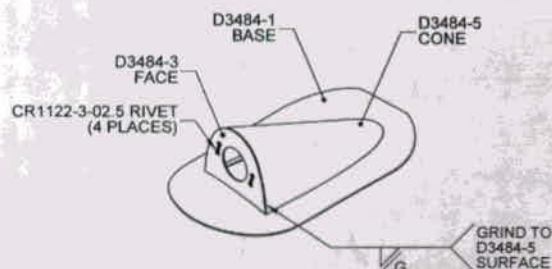
INSTALL MS21069-04  
ANCHOR NUT  
(2 PLACES)

**SECTION B-B**

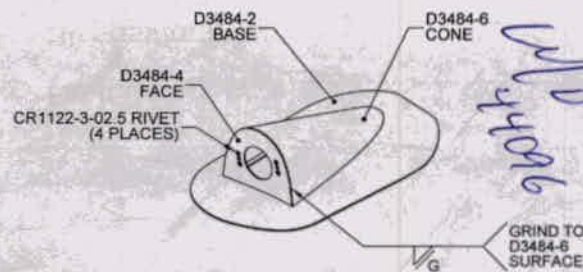


**D3484-041 TAIL LIGHT FAIRING**

**D3484-042 TAIL LIGHT FAIRING**



**D3484-041 ISOMETRIC VIEW**



**D3484-042 ISOMETRIC VIEW**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

E	REDRAWN/RE-FORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS). DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F1-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D3484**  
TITLE  
**TAIL LIGHT FAIRING**  
SCALE  
1:4

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RELEASED  
06.01.10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

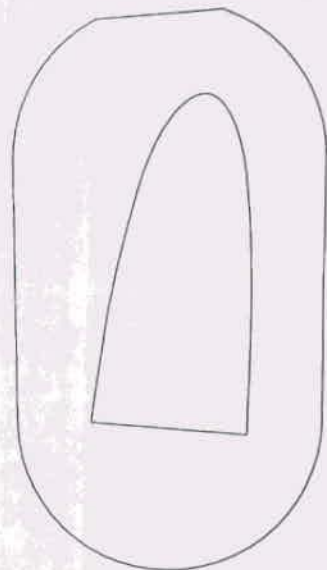
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

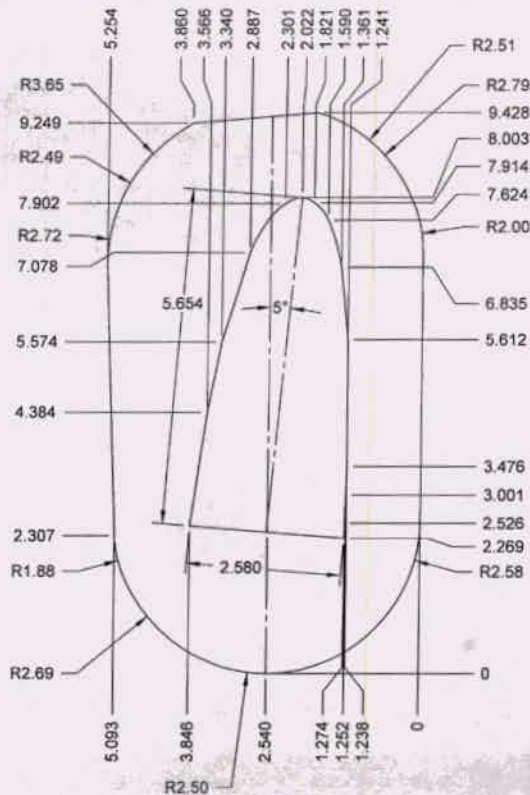




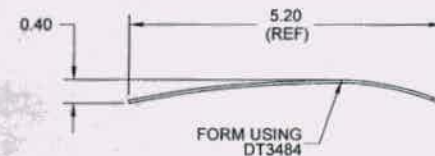
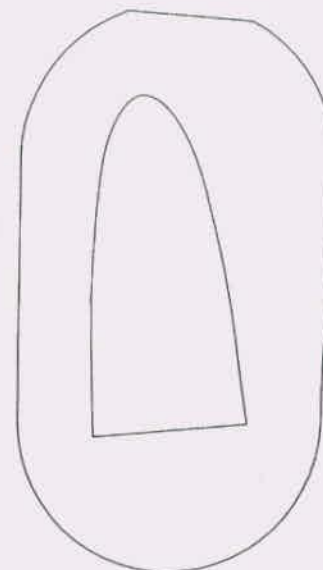
**D3484-1 BASE**  
(MAKE FROM D3484-1F)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs



**D3484-1F BASE FLAT PATTERN**



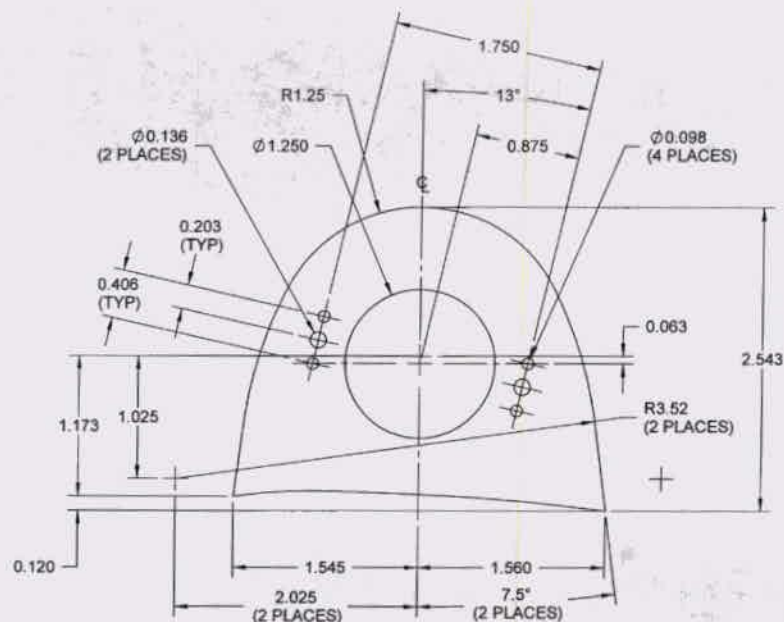
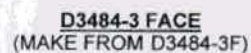
**D3484-2 BASE**  
(MAKE FROM D3484-1F)

**RELEASED**  
08-01-17

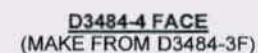
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		<b>D3484</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>TAIL LIGHT FAIRING</b>	1:2
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### D3484-3F FLAT PATTERN TAIL LIGHT FAIRING



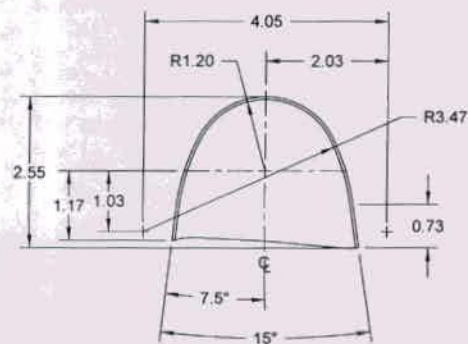
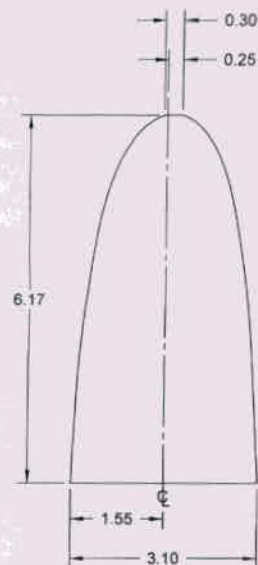
NOTES:  
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.02 lbs

RELEASE  
08-01-17 W

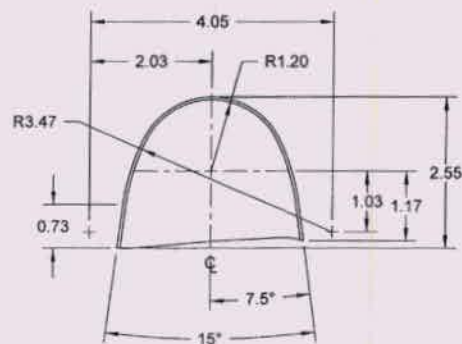
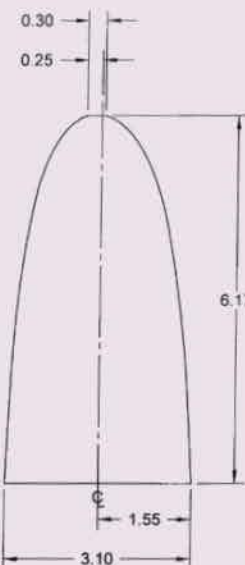
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO <b>D3484</b>  TITLE <b>TAIL LIGHT FAIRING</b>  COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS LOANED TO YOU FOR YOUR INFORMATION ONLY. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. E
DRAWN			SHEET 3 OF 4
CHECKED			SCALE
MFG. APPR.			1:1
APPROVED			
DE APPR.			
DATE	08.01.03		



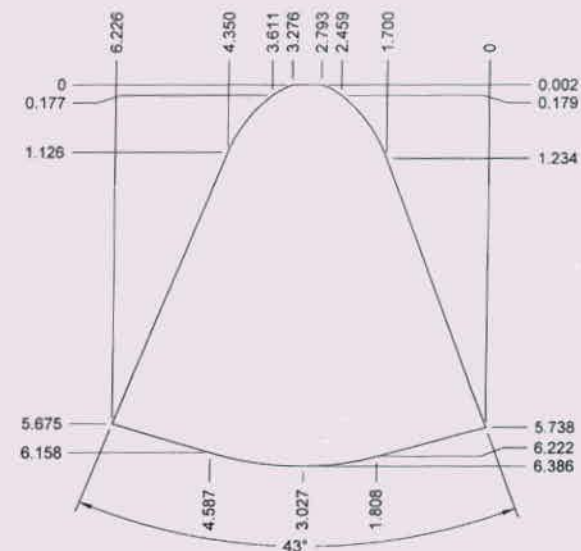




**D3484-5 CONE**  
(MAKE FROM D3484-5F)



**D3484-6 CONE**  
(MAKE FROM D3484-5F)



**D3484-5F CONE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M0061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

11 08.01.07 1/10

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3484	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
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